

Date: Wednesday, 4/19/2006 7:36:22 AM
 User: Kim Johnston



Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
 Job Number : 26704
 Estimate Number : 10553
 P.O. Number : N/A Part Number : D206667103
 This Issue : 4/19/2006 S.O. No. N/A Drawing Number : D206-667-143 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 26703 Material : N/A
 Due Date : 5/30/2006 Qty: 1 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.04.19 N
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
 Skid tubes KJJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

KS 06.05.12

2.0 D6002115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube B19511

Check OD = 2.250"; ID = 1.750"

BG 06.04.28

1

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087

MS 06/04/29

1

2-Turn first side as per Folio FA087

MS 06/04/29

1

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143. MS 06/04/29

1

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/04/29

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:36:22 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

M8 06/04/29 1

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

M8 06/04/29 1

3-Polish entire outside surface of crosstube

M8 06/04/29 1

4-Remove sand and plugs

M8 06/04/29 1

5-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

M8 06/04/29 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

M8 06/04/29 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/07/26 1

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-07-26

9.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

Pm 06-07-28 1

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-07-28 1

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

Pm 06-07-30 1

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg

Pm 06-07-30 1

W/O: -		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

D206-667-143 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

pmc
060731(1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SC 06/08/01 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 0380r

Issue P/O: 1757 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C20 6/08/01 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

AL 06/08/01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC6

DIMENSIONAL CHECK



06-08-02 ①



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

FL 06 08 03 ①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

06-08-04 ①

19.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

06-08-09

20.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip *027545 2T 06 08 06*

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate *027052 2T 06-08-04*

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate *025053 2T 06-08-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Drawing Name: 206L FWD X-TUBE

Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support 319647 IT 06-08-04

24.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

M18523 IT 06-08-06

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp M13792 IT 06-08-04

26.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up. IT 06-08-06

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb IT 06-08-06

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0

PACKAGING 1

PACKAGING RESOURCE #1




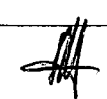
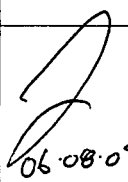


Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/08/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-08-09	27	Dwg deviation for the hole orientation.		re-work as per NCR071 see Attached e-mail.	 06-08-09	 06-08-09	 06-08-11	 06-08-09

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:36:23 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M5399

30.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101648

31.0	AN57A	Bolt
------	-------	------



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

10 AN5-7A Bolt M18536

32.0	AN530A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

4 AN5-30A Bolt M19512

33.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M101369

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev: B

LB 06/08/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 26704

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26-08-10 (2)

Job Completion



26-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26704
Description: Crosstube Assembly (206L High Fwd)	Part Number:	D206-667-143
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.244	✓			
	1.982	+0.005/-0.000	1.983	✓			
	2.019	+0.005/-0.000	2.023	✓			
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.205	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			
SIDE B	104.98	+/-0.020	104.98	✓			
	2.240	+0.005/-0.000	2.244	✓			
	1.982	+0.005/-0.000	1.987	✓			
	2.019	+0.005/-0.000	2.024	✓			
	2.058	+0.005/-0.000	2.063	✓			
	2.097	+0.005/-0.000	2.102	✓			
	2.136	+0.005/-0.000	2.141	✓			
	2.176	+0.005/-0.000	2.180	✓			
	2.201	+0.005/-0.000	2.205	✓			
	0.125	+/-0.010	.125	✓			
	0.400 x 30°	+/-0.010	.400	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.438	✓			

Measured by: BG / MS	Audited by: J.G	Prototype Approval:	N/A
Date: 06/04/29	Date: 06/07/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-07-26

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

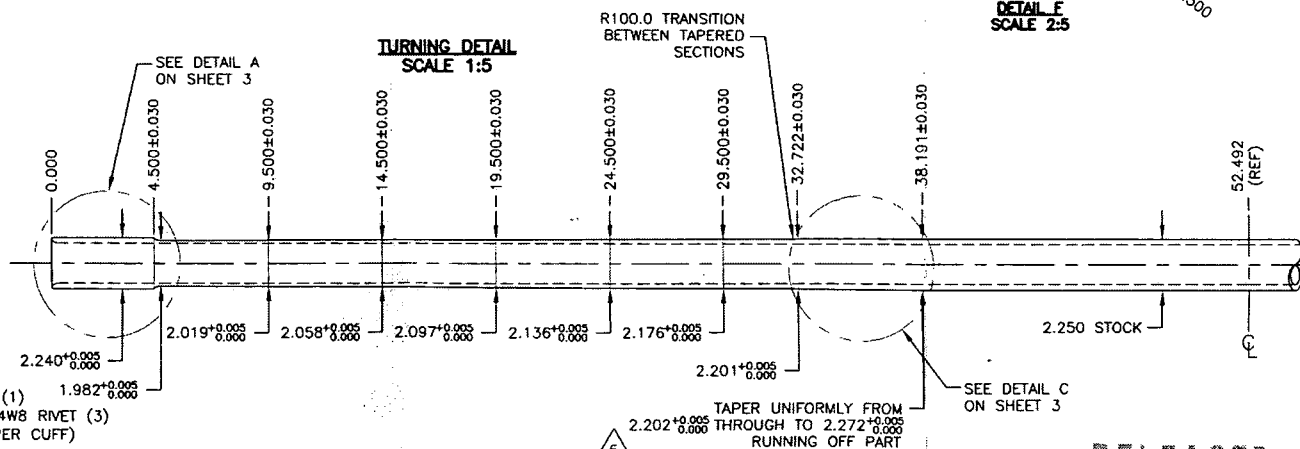
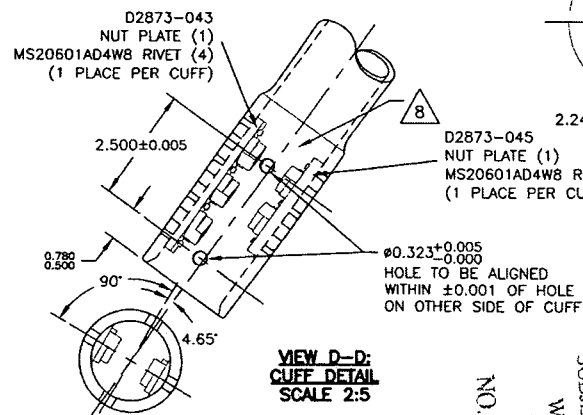
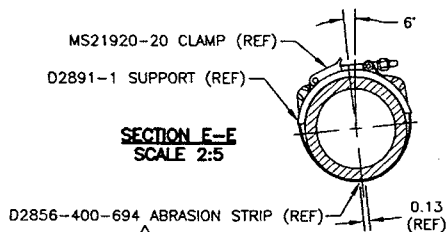
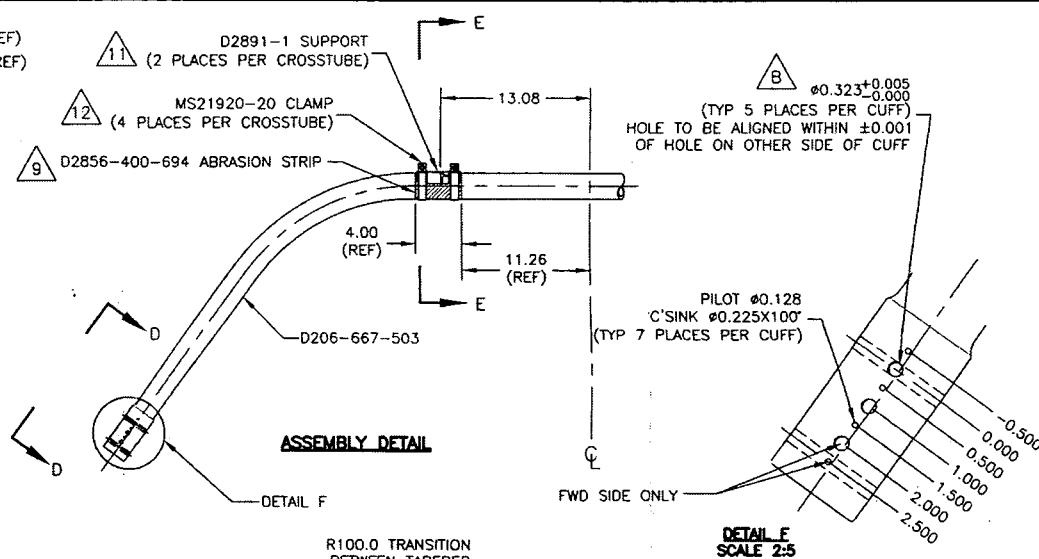
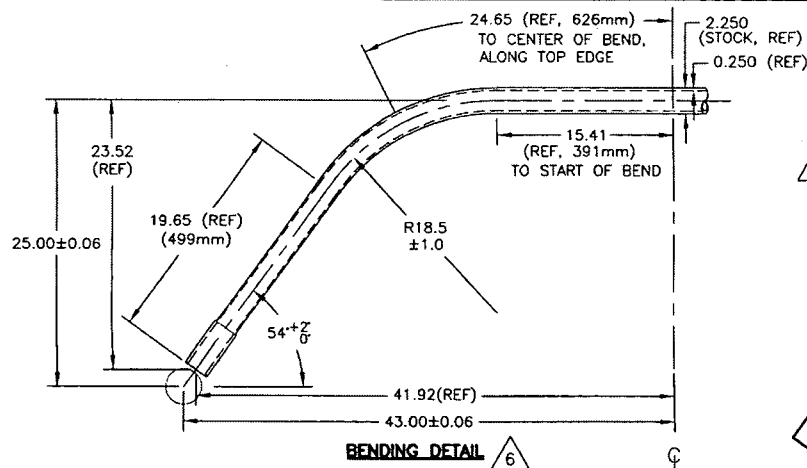
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26704

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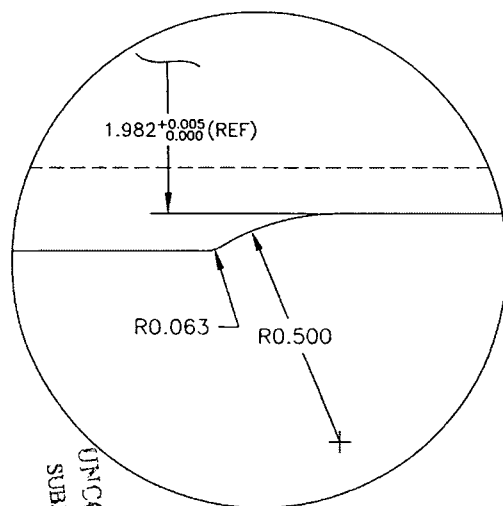
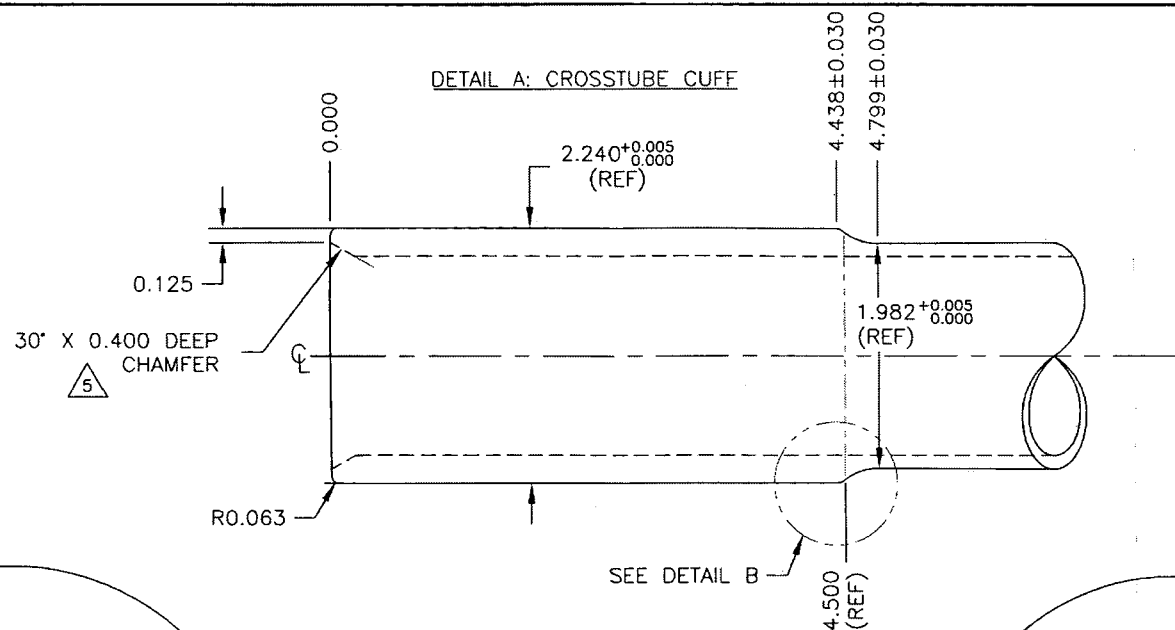


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05-07-26

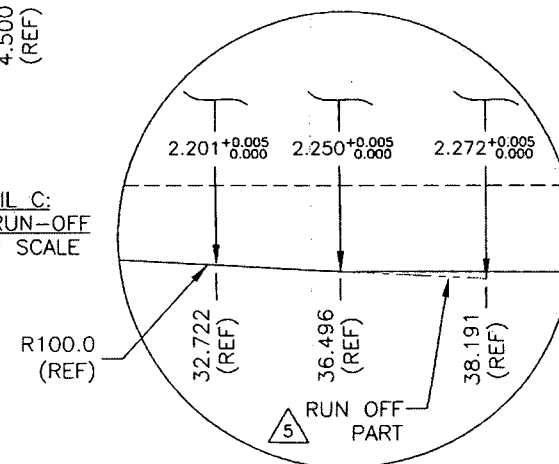
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		CHECKED	APPROVED	DRAWING NO.		REV. E
		JOS	JOS	D206-667-143		SHEET 2 OF 3
		DATE	TITLE	SCALE		
		05.07.26	CROSSTUBE ASS'Y (206L HIGH FWD)	1:10		

NO. 26704
WORK ORDER
WITHOUT NOTICE
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SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
05.07.26

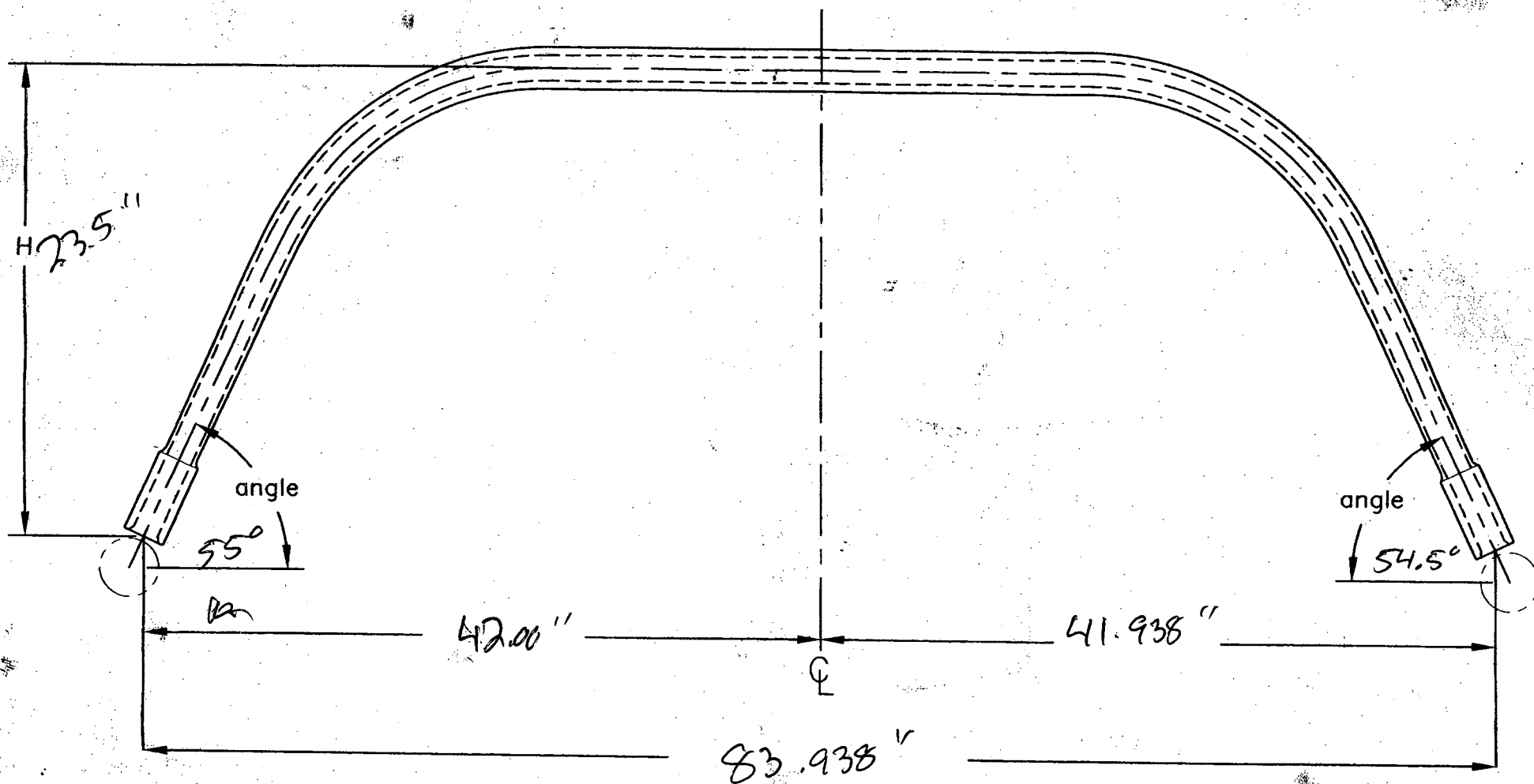


DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 26704
WORK ORDER
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
		DATE	05.07.26			D206-667-143	SHEET 3 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (206L HIGH FWD)	1:1



DATE: 06-07-28

DESCRIPTION: D206-667-103

BATCH NO: B26764

DRAWING: D206-667-193 Rev B

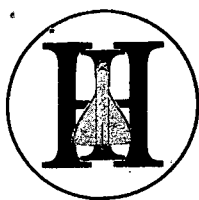
H: 23.52 ± 0.00

1/2 SPAN: 41.92 ± 0.00

TOTAL SPAN: 83.84

ANGLE: 54° ± 2°

[Signature]



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 34601

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of four (4) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (2) P/N D206-667-103

S/N's B26702 & B26704

Qty. (2) P/N D206-667-203

S/N's B27491 & B27492



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on four (4) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

Four (4) cross tubes PASSED inspection.

~~THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS~~

INSPECTED BY:

DATE August 1, 2006

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

00001757

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: August 8, 2006 4:34 PM
To: 'Peter Hum'
Cc: 'Bill Beckett'; 'Serge Shahbazian'
Subject: FW: re-work of 206B and 206L and 407 crosstubes

Peter,

You will also have to remove and re-install the top clamps in the proper orientation.

David

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Tuesday, August 08, 2006 2:11 PM
To: 'Peter Hum'
Cc: 'Bill Beckett '; 'Serge Shahbazian'
Subject: RE: re-work of 206B and 206L and 407 crosstubes

As discussed, this is an acceptable repair scheme for these crosstubes.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Tuesday, August 08, 2006 1:16 PM
To: 'David Shepherd'
Cc: Bill Beckett ; Serge Shahbazian
Subject: re-work of 206B and 206L and 407 crosstubes

David,

With respect to current stock of the 206B, 206L and 407 crosstubes:

It appears the holes for OEM compatibility were drilled on the incorrect sides (i.e. sides requiring 3 holes only have 2; and sides requiring 2 holes have 3); additionally the nut plates are oriented incorrectly

To correct this problem is it acceptable to perform the following

- 1) The D2873-043/-045 radius blocks are installed on the incorrect sides. Remove the D2873-043/-045 radius blocks from all cuffs
- 2) Drill the required hole for the fwd side of the cuff and install the D2873-043 radius block
- 3) Install the required D2873-045 radius block on the aft side of the cuffs***

***On all affected installations, an extra hole will be present on the aft side of all of the cuffs; affected customers/stock will receive a DSI indicating this.

Peter

10/08/2006



HeathAir

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Tél: (514) 636-1000 • Fax: (514) 636-0031

W.O. No 34601

A.M.O. Number: 46/90

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Four (4) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:


S. FLETCHER

DATE:

August 1, 2006

INSPECTION
STAMP(S)

Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER: 00001757

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

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TRAVEL EXPENSES

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